

303 R.O. 750"

Work Order ID **77503**

77503

December-09-11 8:51:37 AM

Page 1

ASAP

Item ID: D3403-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 09/12/2011 Start Qty: 60.00

60

Cust Item ID:

Required Date: 16/12/2011 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: M.L.-J Date: 11/12/09

Tooling:

Date:

Run Start ***NR1***

QC: Date:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3403	D								
100		Hardinge CNC LATHE SMALL	0.00						
100									
Hardinge		Memo	0.00						
Hardinge CNC Lathe Small		1- Turn as per Folio FA925 & Dwg D3403 Folio Rev: <u>N/A</u> Dwg Rev: <u>D</u> 2-Deburr							
110		QC2- Inspect parts off machine FAI/FAIB	0.00						
110									
QC		Memo	0.00						
Quality Control									
120		QC8- Inspect parts - second check	0.00						
120									
QC		Memo	0.00						
Quality Control									

B.A 11/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77503

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 09/12/2011 **Start Qty:** 60.00

60

Cust Item ID:

Required Date: 16/12/2011 **Req'd Qty:** 60.00

60

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
------------	------------	---------------	-------------

Identify as per dwg & Stock Location: () 52

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

OC

Memo

0.00

Quality Control

11/12/14 ~~JD~~
MF
11-12-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-09-11 8:51:41 AM

Page 1

Work Order ID: 77503

77503

Parent Item: D3403-5

D3403-5

Parent Item Name: Bushing

Start Date: 09/12/2011

Required Date: 16/12/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A NEW ISSUE 10-04-23 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	53.4910	0.25	15.78947			

M303R0 750

303 Round Bar 0.750

13.333'

SL 11/12/13

Location

Loc Qty

Loc Code

MAT028

53.491

117328

25.2

117798

4.004

118509

9.809

119346

14.478

13.333'

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	11.02.23	New Issue	KJ 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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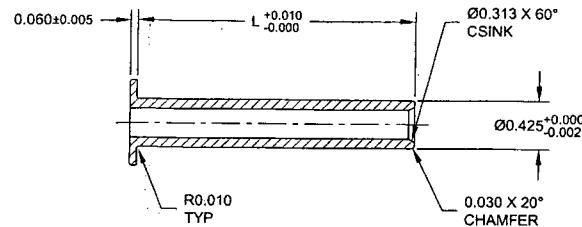
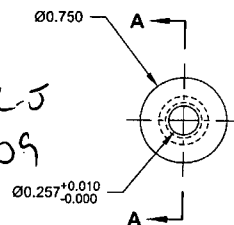
NOTE: Date & initial all entries

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO

SUBJECT TO AMENDM
WITHOUT NOTICE
WORK ORDER

NO. 77563 M.L.J

11/12/09



SECTION A-A

D3403-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3403-1	2.416	0.07
D3403-3	2.165	0.06
D3403-5	2.440	0.07



RELEASED
2011-10-31

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
PER ASTM A582
REF. DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

D	FOR -5, 2.440 WAS 2.500 (PER PAR 11-125)	XDF	11.10.28
C	REFORMAT TO CURRENT STD PER QSI 043; ADDED D3403-S. TOL WAS +0.005/-0.000. REASON: PAR#10-029	MB	10.04.21
B	ADD COUNTERSINK	PH	06.01.23
A	NEW ISSUE	PH	05.03.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.28		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3403	REV. D SHEET 1 OF 1
TITLE BUSHING	SCALE NTS
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